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(71) Applicant (for all designated States except US): **BANNER PHARMACAPS, INC.** [US/US]; 4100 Mendenhall Oaks Parkway, Suite 301, High Point, NC 27265 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **HASSAN, EmadEldin, M.** [EG/US]; 4711 Champion Court, Greensboro, NC 27410 (US). **KINDT, Warren, W.** [US/US]; 3118 Sedgefield Gate Road, Greensboro, NC 27407-6103 (US). **GORDON, Roger, E.** [US/US]; 5803 Wildrose Drive, Greensboro, NC 27410 (US).

(74) Agents: **HICKS, Jack, B.** et al.; 300 North Greene Street, Suite 1900, Greensboro, NC 27401 (US).

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(54) Title: CHEWABLE SOFT CAPSULE

(57) Abstract: A matrix formulation for a soft chewable capsule is provided which includes a gel-forming composition, a plasticizer, a polymer modifier and water. The polymer modifier may be a carboxylic acid or other organic compound that alters the physical and/or chemical properties of the capsule formulation. A chewable soft capsule is also provided, having enhanced organo-leptic and processing properties. An active material may be delivered to a user using this dosage form. A method of forming the chewable soft capsule is also provided.

## **CHEWABLE SOFT CAPSULE**

The present invention relates generally to a chewable matrix composition. The invention also relates to chewable soft capsules and to a process for their preparation, and in particular to chewable soft capsules having a controllable chewable consistency.

### **BACKGROUND**

Chewable dosage forms are manufactured as solids, such as chewable tablets, or elastic semi-solids such as chewing gums, molded gels, or chewable soft capsules. While elastic semi-solid forms provide better mouth feel and customer acceptance, chewable soft capsules have a further benefit of being totally ingestible and can deliver accurate amounts of active ingredients.

Soft capsules formed of a sheath encapsulating a fill or a matrix are one type of dosage form generally used for administering perorally a medicament, vitamin, nutritional supplement, or other material. Certain types of these soft capsules are designed to be chewed by the user. Chewable soft capsules, or chewable soft gels, are traditionally designed so that the user chews upon the capsule to release the fill into the mouth, instead of swallowing the capsule with the fill still encapsulated within the sheath. Chewable capsules are particularly suitable for administering analgesics, vitamins, minerals and cold remedies. After the fill has been released, the user chews the fractured sheath until it is partially or completely dispersed. Alternatively, the sheath may include a chewing gum base material that is not made for swallowing.

Although chewable soft capsules provide an effective dosage system, user acceptance has been limited by the capsules' organo-leptic properties, which are sometimes criticized as being leathery or rubbery, as well as the difficulty that some users experience in consuming the fractured sheaths after the fills have been released. Current soft capsules share the disadvantage of having a distinguishable difference between the sheath and fill in terms of texture and mouth-feel. In addition, they tend to harden over time. The objective of this invention is to address these issues and limitations.

### **SUMMARY**

The present invention is directed generally to a soft capsule useful as a dosage delivery system. The soft capsule, when used as an oral dosage form, exhibits a consistency,

texture and other organo-leptic properties found desirable in a chewable capsule. The capsule, which is suitable for chewing, generally includes a gel-forming polymer, a plasticizer, a polymer modifier, and, water. The capsule also includes an active ingredient that is to be delivered to the user, and optionally contains flavoring agent, sweetener, and/or a taste-masking agent.

In one embodiment, the soft capsule generally includes a matrix encapsulated in a sheath. The matrix is formed of a gel-forming polymer, a first plasticizer, water and a polymer modifier. The sheath is formed of a second gel-forming polymer and a second plasticizer. The active ingredient may be contained within the matrix. One or both of the first and second gel-forming polymers may be a gelatin that exhibits a bloom in a predetermined range.

In one particular embodiment, the matrix includes a gelatin exhibiting a bloom in the range of about 0 to about 250. The sheath includes a gelatin that exhibits a bloom in the range of about 80 to about 250.

In another embodiment, the soft capsule has a matrix formed of a gelatin that exhibits a bloom in the range of about 0 to about 80 and a sheath that exhibits a bloom in the range of about 100 to about 150.

In yet another embodiment, the matrix includes a gelatin exhibiting a bloom in the range from about 20 to about 250.

In yet another embodiment, the matrix includes a gelatin exhibiting a bloom in the range from about 40 to about 80.

The polymer modifier used to form the matrix of the soft capsule of the present invention generally includes a carboxylic acid. In one embodiment, the polymer modifier used to form the matrix of the soft capsule is selected from lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid and combinations thereof.

The plasticizer used to form the matrix and/or sheath of the soft capsule may include a polyol. In another particular embodiment, the soft capsule is formed using a plasticizer selected from glycerol, sorbitol, maltitol, xylitol, and combinations thereof.

A method of making a soft capsule is also encompassed by the present invention. The method generally includes the step of combining a gel-forming polymer with a polymer modifier, incubating the combined gel-forming polymer and polymer modifier to form a matrix;  
and, encapsulating the matrix to form a chewable soft capsule.

In one embodiment, the method of forming a chewable soft capsule for administering an oral dosage of an active ingredient includes the steps of: mixing a gelatin, a plasticizer, a polymer modifier and water together to form a matrix, incubating the matrix, cooling the matrix, and encapsulating the matrix in a sheath. In this embodiment, the gelatin exhibits a bloom in the range of about 0 to about 250 and the plasticizer includes a polyol. Also, the polymer modifier includes a carboxylic acid and the sheath includes a plasticizer and a gelatin that exhibits a bloom in the range of about 80 to about 250.

These and other embodiments and advantages are contemplated by the present invention, which is set forth in detail below.

### **DETAILED DESCRIPTION**

This invention provides chewable soft gel compositions that minimize or reduce the traditional user's complaints regarding a perceived major difference in texture between the matrix and the capsule shell or sheath that is a result of the current technology. Therefore, this invention describes a chewable softgel compositions with homogeneous, controllable mouth-feel for the whole capsule.

The soft gel is made from a hydrophilic matrix comprising a gel-forming polymer and its oligomers or hydrolysates, in presence of a polymer modifier that can control the texture, viscosity, and melting point of the matrix. In addition, the sheath comprises a polymer modifier, along with the gel-forming polymer composition, and plasticizer. Such a combination has the benefit of providing a stable composition where mass transfer between the shell and the matrix is reduced due to the structural similarity between the matrix and the shell.

A soft capsule exhibiting organo-leptic properties that are appropriate for use as a chewable dosage form for delivering therapeutic, diagnostic and/or dietary agents is set forth herein. The organo-leptic properties of the soft capsule, such as, for example, texture and chewiness, are enhanced by the polymer modifier included in the capsule formulation. In addition, the polymer modifier enhances the physical and/or chemical properties of the gel-

forming polymers that are used to form the capsule matrix and/or sheath, thereby facilitating the processing of the soft capsule. The soft capsules generally include a hydrophilic, water-soluble matrix that includes one or more active ingredients and is encapsulated in hydrophilic, water-soluble sheath. The matrix and the sheath are generally formed of similar materials, although variations in their compositions are contemplated by the present invention.

As used herein, the terms "gel-forming polymer" and "gel-forming composition" refer to any natural or synthetic polymeric material or partial hydrolysate of a polymer that can form a gel when appropriately dissolved or dispersed in water or aqueous media. Examples of gel-forming compositions include proteins such as different types of gelatins from different sources. Specific examples are: acid and lime bone bovine gelatins; pig bone gelatin; skin pig gelatin; skin bovine gelatin; and fish gelatin. Other examples of gel-forming compositions are of polysaccharide nature. Specific examples are: sodium and calcium alginate; natural and modified starch and starch hydrolysates; pectins and amylopectins; and cellulose derivatives, such as hydroxypropyl-methyl cellulose, and carboxymethyl cellulose, and salts thereof. A gel-forming composition can be a hydrophilic polymer, alone or in combination with its building units, its oligomers or hydrolysate. As used in the present description, the term "active ingredient" is intended to include therapeutic, diagnostic or nutritional agents, such as medicaments, vitamins, minerals, fruit extracts, herbals and other encapsulatable materials that are intended for local effect in the mouth or the gastro-intestinal tract, or for systemic effect, or combinations thereof understood by those skilled in the art to support the desired effect. Examples of active ingredients useful in this application are: anti-asthmatic drugs such as salbutamol, theophylline; anti-epileptic drugs such as phenytoin; analgesics such as paracetamol, naproxen, ibuprofen, aspirin, meloxicam, and celecoxib; nonsteroidal anti-inflammatory drugs (NSAIDs); beta-lactam antibiotics such as amoxycillin; macrolide antibiotics such as azithromycin, and clarythromycin; mineral supplements, such as iron, potassium, calcium, magnesium supplements and salts thereof; and vitamins, such as vitamins C, B complex, A, E, K, and D; and other food supplements.

As used herein, "polymer modifier" refers to a pharmaceutically acceptable compound that has the ability, under the appropriate process conditions, to alter one or more physical and/or chemical properties of one or more of the gel-forming polymers disclosed herein or generally known for use in soft capsule formulations, so as to enhance the

performance characteristics of the capsule formulation during processing and/or the performance characteristics and/or physical properties of the finished capsule product.

The polymer modifier of the present invention is included in the soft capsule of the present invention in order to alter one or more physical and/or chemical characteristics of the gel-forming polymers that are contained in the capsule formulations. As an example, the polymer modifier may reduce the melting point of the gel-forming polymer in the matrix formulation. With the melting point reduced, less heat is required to place the gel-forming polymer in a liquid state, thereby reducing the energy cost and time required to process the formulation and allowing the incorporation of heat-sensitive drugs or agents.

In addition to a possible reduction in the melting point of the gel-forming polymer, the polymer modifier may reduce the viscosity of one or more of the gel-forming compositions found in the capsule formulation, thereby providing a formulation that may flow more easily during processing (a "flowable" composition). Again, capsule manufacturing may be facilitated by such an alteration. Gel modifier can also prevent gel hardening upon gel storage and improve the disintegration and dissolution of the chewable products in the mouth.

A third illustrative example of the effect that the polymer modifier may have is a reduction of the molecular weight of one or more gel-forming polymers of the capsule formulation. Such a reduction also tends to affect other physical properties of the gel-forming polymers, both during capsule production and in the finished capsule product.

The polymer modifier of the present invention also may enhance the texture or chewiness of the finished soft capsule. The capsule texture may tend to be less "leathery" than it would be in the absence of the polymer modifier, thereby providing a more acceptable mouth feel for the capsule user.

Although these particular examples are set forth herein describing the possible impact the polymer modifier has upon the capsule formulation and the finished capsule product, these examples are provided for the purpose of illustration and not to limit the scope of the present invention. These specific possible effects need not occur in order for a capsule formulation to fall within the scope of the present invention. Indeed, these and/or other effects may be realized by the inclusion of a polymer modifier into a capsule formulation, thereby providing a soft capsule that is acceptable for chewing.

Soft gel capsules generally are produced by a rotary die process as set forth by J. P. Stanley in "The Theory and Practice of Industrial Pharmacy," L. Lachman, (editor), Lea and

Febiger (publisher), Philadelphia (1976), which is incorporated by reference as if fully set forth herein. In the process of the invention, a molten mass of a gel-forming polymer, such as, for example, a gelatin formulation, is fed from a reservoir onto drums to form two spaced sheets or ribbons of gelatin in a semi-molten state. These ribbons are fed around rollers and brought together at a convergent angle into the nip of a pair of roller dies that include opposed die cavities. A matrix containing an active ingredient to be encapsulated is fed into the wedge-shaped joinder of the ribbons.

The gelatin ribbons are continuously conveyed between the dies, with portions of the matrix being trapped between the sheets inside the die cavities. The sheets are then pressed together, and severed around each die so that opposed edges of the sheets flow together to form a continuous gelatin sheath around the entrapped medicament. The part of the gelatin sheet that is severed from the segments forming the capsules may then be collected for recycling. The very soft capsules are then dried to increase the integrity of the sheath, and packaged for later distribution and consumption.

The chewable soft capsules of the present invention are generally formed by combining the gel-forming composition, polymer modifier, plasticizer, and water with or without mixing, and while maintaining the heat of the mixture in a range between about 40 and about 75 degrees Celsius. This matrix mixture is then allowed to incubate for about 4 to about 72 hours, while its temperature is maintained in the range of about 40 to about 75 degrees Celsius. The matrix mixture is then cooled to a temperature in the range of about 30 to about 40 degrees Celsius. The matrix mixture is then encapsulated. The capsules are then air-cooled to a temperature in the range of about 5 to about 25 degrees Celsius. The capsules are also dried to a final water content of a range of about 5 to about 20 percent by weight. Final water content can also be from about 5 to about 10 percent. Prior to drying, the matrix can comprise water from about 20% to about 50% by weight. Prior to drying, water content can also be about 25% to about 35% by weight. Active ingredients can be added from the start of preparing the gel mass, if they are chemically and physically stable. Unstable actives can be added, preferably as a last step before encapsulation to minimize any possibility for degradation. The performance properties of a gel-forming composition are affected in part by its cohesive strength, which, in the case of at least gelatin, is expressed as "bloom." This bloom value is determined by measuring the weight in grams required to move a plunger 0.5 inch in diameter, 4 mm into a 6.67% gelatin gel that has been held for 17 hours at 10°C.

Chewable soft gel capsules are designed to at least partially disperse or dissolve in the user's mouth, upon chewing, within a brief period of time so that the chewable mass can be swallowed. Therefore, in addition to the above properties, the remains of the capsule should tend to be soluble after the active ingredient has been released. These remains should also have a good "mouth feel." As used herein, "mouth feel" describes chewability. Chewing the capsule remains should be a pleasant, or at least not an unpleasant sensation that results in a swallowable composition.

Surprisingly, it has been found that a chewable soft capsule having these desired characteristics can be produced from a capsule formulation including an appropriate amount of polymer modifier that alters one or more characteristics of the gel-forming composition therein. Such a capsule formulation, examples of which are provided below, has been found to produce chewable soft capsules that exhibit a desirable mouth-feel and solubility.

In one embodiment, the matrix formulation, prior to drying, of the present invention includes the following ingredients in the specified percentages:

Table 1. Matrix Formulations

INGREDIENT	% BY WEIGHT
Gel-Forming composition	15-80
Polymer modifier	0.1-10
Plasticizer	5-40
Water	5-30
Active Ingredient	0.01-70
Other Ingredients, <i>e.g.</i> , flavors, sweeteners, and taste- masking known in the industry	0.01- 15

The gel-forming polymer of the above embodiment may be a gelatin that exhibits a bloom in the range of about 0 to about 250. The plasticizer may be a polyol, such, for example, glycerol, sorbitol, maltitol, xylitol, or combinations thereof. The polymer modifier may be a mono, di, or poly carboxylic acid. More specifically, the polymer modifier may be lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid or a combination of two or more of these acids.

In this embodiment, the capsule may also include a sheath formulation (before drying) including the following ingredients in the specific ranges:

Table 2. Sheath Formulations

INGREDIENT	% BY WEIGHT
Gel-Forming composition	25-55
Plasticizer	5-40
Water	15-40
Other Ingredients, <i>e.g.</i> color, flavor, or sweetener.	0.1-10



As with the matrix formulation, the gel-forming polymer may be a gelatin. The gelatin may exhibit a bloom in the range of about 80 to about 250. The plasticizer of this sheath formulation may be a polyol, such as, for example, a polyol selected from glycerol, sorbitol, maltitol, xylitol, or combinations thereof.

In another embodiment, the matrix formulation includes the following ingredients in the specified ranges, after drying:

**Table 3. Matrix Formulations**

INGREDIENT	% BY WEIGHT
Gel-Forming composition	30-70
Polymer modifier	0.25-5
Plasticizer	10-30
Water	5-15
Active Ingredient	1-25
Other Ingredients	0.1-5

Again, the matrix formulation may include a gelatin as the gel-forming polymer. In this instance, the gelatin may exhibit a bloom in the range of about 0 to about 80. Likewise, the plasticizer may be a polyol, such as one selected from the list set forth above. Also, the polymer modifier again may be a carboxylic acid, such as one selected from the list above.

In this embodiment, the capsule formulation also may include a sheath that includes the following ingredients in the specified ranges.

**Table 4. Sheath Formulations, after drying**

INGREDIENT	% BY WEIGHT
Gel-Forming composition	10-70
Plasticizer	10-30
Water	5-15
Other Ingredients	0.1-10

The gel-forming polymer of this sheath formulation may be a gelatin, which exhibits a bloom in the range of about 100 to about 175.

It will be understood that different percentages may be selected within the above ranges so that the sum of the percentages of the sheath ingredients is equal to 100%. If additional ingredients are used, the percentages will be adjusted within the ranges listed to accommodate the additional ingredients.

In the case of a capsule formulation including both a matrix and a sheath, the matrix may include a first gel-forming polymer and a first plasticizer and the sheath may include a second gel-forming polymer and a second plasticizer. Depending upon the specific

formulation, the first and second gel-forming polymers may be either identical to each other or differ in their chemical compositions, bloom values and/or amounts. Likewise, the first and second plasticizers may be identical or differ in their compositions and/or amounts.

The chewable soft capsule formed from the above mixture, after being dried for storage and subsequent use, is comprised of the following ingredients in the specified parts by weight:

Table 5. Capsule Composition, after drying

INGREDIENT	% BY WEIGHT
First Gel-Forming Polymer	20-80
Second Gel-Forming Polymer	5-25
First Plasticizer	10-40
Second Plasticizer	1-10
Polymer Modifier	0.5-10
Active Ingredient	0.01-70
Other Ingredients	0.1-15
Water	5-20

### EXAMPLES

#### Examples 1-5

The following examples describe the manufacture and testing of various matrix formulations for acceptable practice.

Gelatin, gelatin hydrolysate, and glycerol were mixed and heated to about 65° C overnight. Citric acid was then added and masses were molded and dried at 20° C under low humidity (20-30%) till the total water content reached about 10%. Dried samples were tested for hardness, water content, and other texture analysis. The hardness ranged from about 1 to about 100 gram force, using a texture analyzer fitted with a round ball probe. The following example formulations are provided for purposes of illustration of certain aspects of the present invention and are not intended to limit the scope thereof. The optimum percentages of each ingredient will depend upon the overall formulation contents, and the identity of the individual ingredients. However, evaluation and selection of the most desirable formulation will be well within the skill of practitioners in this area, once they are familiar with the present disclosure.

The values provided in Table 1 for each compound represent the parts per weight of that compound, and the corresponding hardness obtained:

TABLE 6. Matrix Compositions Examples 1-5

	1	2	3	4	5
COMPONENT					
Gelatin	5.9	10	10	10	0
Complete Gelatin Hydrolysate	5.9	10	10	10	10
Sorbitol	14.1	10	20	0	10
Glycerol	5.9	0	10	10	10
Water					
Citric Acid	1.4	1.0	1.0	1.0	1.0
Hardness(g) by Texture Analyzer	4	103	7	59	1

Hardness was measured after drying. The above amounts are in weight ratios. Water was adjusted so that the water % is constant and around 28% of the mass before drying. A complete gel hydrolysate is a hydrolyzed gelatin that has zero bloom (as used herein, the term "hydrolysate" may indicate a partial or complete hydrolysate, as indicated in the context where the term is used).

#### Example 6 – A Soft Chewable Capsule Composition

A soft chewable capsule composition according to the invention can include the following matrix and sheath:

Table 7. Capsule Composition

MATRIX COMPOSITION		SHEATH COMPOSITION	
glycerol	27.1	glycerol	16.96
gelatin (60-80 bloom)	9.03	sorbitol	16.96
sorbitol	9.03	gelatin (100 bloom)	39.92
gel hydrolysate	27.1	citric acid	1
citric acid	1.79	water	24.95
sucralose	0.15	flavor	0.2
water (prior to drying)	25.58	color	0.004
flavor	0.2		
color	0.004		

#### Example 7: Effect of the Polymer Modifier on Matrix Properties

A gel matrix consisting 14.6% gelatin (60-80 bloom), 14.6% glycerin, 14.6% SORBITOL SPECIAL™ (SPI Polyols, Inc. New Castle, Delaware), 40% water (before drying) and 1.48%

citric acid was made by subjecting the mixture to heat at 60°C for about 2 hours. The cooked matrix had a melting point of 29° C. After 24 hours of incubation, the same matrix had a melting point of 25.3° C and its viscosity was reduced to 52% of the initial value, as measured by a cone and plate rheometer (TA instruments, Leatherhead, England).

**Example 8: Matrix and Sheath Composition and Method of Manufacturing**

A matrix composition consisting of:

Gelatin(60-80 Bloom)	9.68
Gelatin hydrolysate	29.05
Citric acid	1.80
Sucralose	0.15
Glycerin	21.28
Water	25.12
Color and flavor, add to	100.00

Gelatin and gel hydrolysate were dissolved in water in presence of the plasticizer at about 60° C. The polymer modifier was also added to the mass and was allowed to modify the mass structure by incubation at 60° C for 12 hours. The above matrix formula had water activity of 0.39. After incubation, encapsulation was performed using a rotary die machine, with the following gel sheath composition:

Gelatin(100 Bloom)	39.92
Citric acid	1.00
SORBITOL SPECIAL™	19.57
Glycerin	19.57
Water	24.95
Color	0.004

Capsules were dried in a tumble drier where cold air was initially used to congeal the capsule mass and keep the shell shape integrated. Drying was then completed using a tunnel dryer. Dried capsules had a 9.8% water content, and firm texture (a hardness peak of 91.9 gram force ) as measured using a TA-XT2 texture analyzer (Texture Technologies, Scarsdale, New York) using a standard two bite texture profile analysis with a .25 inch diameter probe at room temperature.

**Example 9: Matrix and Sheath Composition and Method of Manufacturing:**

The matrix composition consisted of:

Gelatin(60-80 Bloom)	9.03
Gelatin hydrolysate	27.09

Citric acid	1.79
Sucralose	0.14
Glycerin	36.18
Water	25.56
Color and flavor, added to	100.00

Gelatin and gel hydrolysate were dissolved in water in presence of the plasticizer at about 60 C. The polymer modifier was also added to the mass and was allowed to modify the mass structure by incubation at 60° C for 12 hours. After incubation, encapsulation was performed using a rotary die machine, with the following gel sheath composition:

Gelatin(100 Bloom)	39.92
Citric acid	1.00
SORBITOL SPECIAL™	19.57
Glycerin	19.57
Water	24.95
Color	0.004

Capsules were dried in a tumble drier where cold air was initially used to congeal the capsule mass and keep the shell shape integrated. Drying was then completed using a tunnel dryer. Dried capsules had a 10% water content, and softer texture (a hardness peak of 22.7 gram force ) as measured using a TA-XT2 texture analyzer using a standard two bite texture profile analysis with a 0.25 inch diameter probe at room temperature.

#### Example 10: Chewable Soft Capsule Matrix Containing Active Ingredient in Solution

A chewable soft capsule formulation contains 6.25 mg per unit dose of the antihistaminic, diphenhydramine was manufactured using the methods explained in examples 9 and 10 where the active was incorporated to the fill matrix after the incubation with the polymer modifier.

The matrix consisted of 9% gelatin (60-80 bloom), 26.9% gelatin hydrolysate 26.9% glycerin, 9% sorbitol special, 1.8 % citric acid, 24.7% water, and less 1% of sweetener, color, and flavor.

#### Example 11: Chewable Soft Capsule Matrix Containing Active Ingredient as a Suspension

A chewable soft capsule matrix containing 80 mg per dose of the analgesic antipyretic active, Paracetamol was manufactured using the methods explained in examples 9 and 10 where the active was incorporated to the fill matrix after the incubation with the polymer modifier. The matrix consisted of 8.1% gelatin (60-80 bloom), 24.4% gelatin hydrolysate

31.8% glycerin, 1.6% citric acid and 10.8% Paracetamol as coated powder.

Certain modifications and improvements will occur to those skilled in the art upon a reading of the foregoing description. It should be understood that all such modifications and improvements are properly within the scope of the following claims.

What is claimed is:

1. A chewable soft capsule suitable for chewing having a matrix comprising:  
at least one gel-forming composition comprising a polymer, oligomer, monomer, polymer hydrolysate, or combinations thereof;  
at least one plasticizer;  
at least one polymer modifier; and,  
water.
2. The chewable soft capsule of claim 1, wherein said plasticizer is a polyol.
3. The chewable soft capsule of claim 1, wherein said plasticizer is selected from the group consisting of glycerol, sorbitol, maltitol, xylitol, and combinations thereof.
4. The chewable soft capsule of claim 1, wherein said polymer modifier is an acid.
5. The chewable soft capsule of claim 1, wherein said polymer modifier is selected from the group consisting of a carboxylic acid, lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid, salts of the foregoing, and combinations of the foregoing.
6. The chewable soft capsule of claim 1, wherein said polymer modifier is citric acid.
7. The chewable soft capsule of claim 1, wherein said polymer modifier includes a combination of at least two carboxylic acids selected from the group consisting of lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid, salts of the foregoing, and buffers of the foregoing.
8. The chewable soft capsule of claim 1, wherein said gel-forming composition is a gelatin or gelatin hydrolysate that exhibits a bloom in the range of about 20 to about 250.
9. The chewable soft capsule of claim 1, wherein said gel-forming composition is a gelatin or gelatin hydrolysate that exhibits a bloom in the range of about 60 to about 80.

10. The chewable soft capsule of claim 1, further comprising an active ingredient.
11. The chewable soft capsule of claim 10, wherein said active ingredient is selected from the group consisting of NSAIDs, analgesics, antihistimines, anti-asthmatics, anti-epileptics, antibiotics, decongestants, anti-allergenics, and food supplements.
12. The chewable soft capsule of claim 1, wherein said matrix comprises water from about 20% to about 50% by weight.
13. The chewable soft capsule of claim 1, wherein the matrix comprises water from about 25% to about 35% by weight.
14. A chewable soft capsule comprising:
  - a matrix comprising a first gel-forming composition comprising a polymer, oligomer, monomer, polymer hydrolysate, or combinations thereof; a first plasticizer; a polymer modifier; water; and an active ingredient; and,
  - a sheath, wherein said sheath includes a second gel-forming composition and a second plasticizer.
15. The chewable soft capsule of claim 14, wherein said first gel-forming composition is a partially hydrolyzed gelatin.
16. The chewable soft capsule of claim 15, wherein said gelatin exhibits a bloom in the range of about 20 to about 250.
17. The chewable soft capsule of claim 15, wherein said gelatin exhibits a bloom in the range of about 40 to about 80.
18. The chewable soft capsule of claim 14, wherein said second gel-forming composition is a gelatin.



19. The chewable soft capsule of claim 18, wherein said gelatin exhibits a bloom in the range of about 80 to about 250.
20. The chewable soft capsule of claim 18, wherein said gelatin exhibits a bloom in the range of about 100 to about 150.
21. The chewable soft capsule of claim 14, wherein said polymer modifier is an acid.
22. The chewable soft capsule of claim 14, wherein said polymer modifier is selected from the group consisting of a carboxylic acid, lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid, salts of the foregoing, and combinations of the foregoing.
23. The chewable soft capsule of claim 14, wherein said polymer modifier is citric acid.
24. The chewable soft capsule of claim 14, wherein said polymer modifier comprises a combination of at least two carboxylic acids selected from the group consisting of lactic acid, fumaric acid, tartaric acid, citric acid, and glycolic acid.
25. The chewable soft capsule of claim 14, wherein said matrix comprises about 20 to about 80 percent by weight of said first gel-forming composition.
26. The chewable soft capsule of claim 14, wherein said matrix comprises about 30 to about 70 percent by weight of said first gel-forming composition.
27. The chewable soft capsule of claim 14, wherein said matrix comprises about 5 to about 40 percent by weight of said first plasticizer.
28. The chewable soft capsule of claim 14, wherein said matrix comprises about 10 to about 30 percent by weight of said first plasticizer.
29. The chewable soft capsule of claim 14, wherein said matrix comprises about 0.1 to about 10 percent by weight of said polymer modifier.

30. The chewable soft capsule of claim 14, wherein said matrix comprises about 0.25 to about 5 percent by weight of said polymer modifier.
31. The chewable soft capsule of claim 14, wherein said matrix comprises about 20% to about 50% by weight water.
32. The chewable soft capsule of claim 14, wherein said matrix comprises about 25% to about 35% by weight water.
33. The chewable soft capsule of claim 14, wherein said sheath comprises about 60 to about 95 percent by weight of said second gel-forming composition.
34. The chewable soft capsule of claim 14, wherein said sheath comprises about 5 to about 40 percent of said second plasticizer.
35. The chewable soft capsule of claim 14, wherein said active ingredient is selected from the group consisting of NSAIDs, analgesics, antihistimines, anti-asthmatics, anti-epileptics, antibiotics, decongestants, anti-allergens, and food supplements.
36. A chewable soft capsule comprising:
  - a matrix, wherein said matrix comprises from about 20 to about 80 percent by weight of a gel-forming composition comprising a polymer, oligomer, monomer, polymer hydrolysate, or combinations thereof; from about 5 to about 40 percent by weight of a plasticizer; from about 0.1 to about 10 percent by weight of a polymer modifier; from about 20 to about 50 percent by weight water; and an active ingredient.
37. The chewable soft capsule of claim 36, further comprising a sheath, wherein said sheath comprises from about 60 to about 95 percent by weight of a gel-forming polymer, and from about 5 to about 40 percent by weight of a plasticizer.
38. The chewable soft capsule of claim 36, wherein said polymer modifier is an acid.

39. The chewable soft capsule of claim 36, wherein said polymer modifier is selected from the group consisting of a carboxylic acid, lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid, salts of the foregoing, and combinations of the foregoing.
40. The chewable soft capsule of claim 36, wherein said polymer modifier is citric acid.
41. The chewable soft capsule of claim 36, wherein said polymer modifier comprises a combination of at least two carboxylic acids selected from the group consisting of lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid, and salts and buffers thereof.
42. The chewable soft capsule of claim 36, wherein said gel-forming composition is selected from the group consisting of carbohydrates, carbopolymers, polysaccharides, starch, modified starch, alginates, hydroxypropylmethyl cellulose, methyl cellulose, proteins, gelatins, or combinations thereof.
43. The chewable soft capsule of claim 36, wherein said active ingredient is selected from the group consisting of NSAIDs, analgesics, antihistimines, anti-asthmatics, anti-epileptics, antibiotics, decongestants, anti-allergens, and food supplements.
44. The chewable soft capsule of claim 36, wherein said gel-forming composition is a gelatin exhibiting a bloom from about 20 to about 250.
45. The chewable soft capsule of claim 36, wherein said gel-forming composition is a gelatin exhibiting a bloom from about 40 to about 80.
46. A chewable soft capsule comprising:
  - a matrix, wherein said matrix comprises a gelatin, a polymer modifier, a plasticizer, water and an active ingredient, wherein said gelatin exhibits a bloom from about 20 to about 250, wherein said polymer modifier comprises a carboxylic acid, and wherein said plasticizer comprises a polyol; and,

a sheath, wherein said sheath comprises a gelatin and a plasticizer, wherein said gelatin exhibits a bloom of about 80 to about 250, and wherein said plasticizer comprises a polyol.

47. The chewable soft capsule of claim 46, wherein said matrix includes 0.1 to about 10 percent by weight of said carboxylic acid.
48. The chewable soft capsule of claim 46, wherein said carboxylic acid is selected from the group consisting of a lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid, salts of the foregoing, and combinations of the foregoing.
49. The chewable soft capsule of claim 46, wherein said carboxylic acid is citric acid.
50. The chewable soft capsule of claim 46, wherein said polyol is selected from the group consisting glycerol, sorbitol, maltitol, xylitol and combinations thereof.
51. The chewable soft capsule of claim 46, where said active ingredient is selected from the group consisting of NSAIDs, analgesics, antihistimines, anti-asthmatics, anti-epileptics, antibiotics, decongestants, anti-allergenics, and food supplements.
52. A method of making a chewable soft capsule comprising:
  - combining a gel-forming composition comprising a polymer, oligomer, monomer, polymer hydrolysate, or combinations thereof, with a polymer modifier;
  - incubating the combined gel-forming composition and polymer modifier for a sufficient time to form a flowable matrix ; and,
  - encapsulating the matrix to form a chewable soft capsule.
53. The method of claim 52, wherein said polymer modifier is an acid.
54. The method of claim 52, wherein said polymer modifier is selected from the group consisting of a carboxylic acid, lactic acid, fumaric acid, tartaric acid, citric acid, glycolic acid, salts of the foregoing, and combinations of the foregoing.

55. The method of claim 52, wherein said polymer modifier is citric acid.
56. The method of claim 52, wherein the matrix comprises about 0.1 to about 10 percent by weight polymer modifier.
57. The method of claim 52, wherein the matrix comprises about 0.25 to about 5 percent by weight polymer modifier.
58. The method of claim 52, wherein the combining step further comprises adding water and a plasticizer to the gel-forming composition.
59. The method of claim 52, wherein the gel-forming composition is a gelatin exhibiting a bloom in the range of about 20 to about 250.
60. The method of claim 52, wherein the gel-forming composition is a gelatin exhibiting a bloom in the range of about 40 to about 80.
61. The method of claim 52, wherein the encapsulating step comprises combining the matrix with a sheath, said sheath comprising a gel-forming polymer and a plasticizer.
62. The method of claim 52, wherein the incubating step is for about 4 to about 72 hours.
63. The method of claim 52, wherein the temperature of the combined gel-forming composition and polymer modifier is maintained in a range of about 40°C to about 75°C during the incubating step.
64. The method of claim 52, further comprising cooling the matrix prior to the encapsulating step.
65. The method of claim 52, further comprising adjusting the water content of the chewable soft capsule to a range of about 5 to about 20 percent by weight.

66. A method of forming a chewable soft capsule for administering an oral dosage of an active ingredient comprising the steps of:
- mixing a gelatin composition, a plasticizer, a polymer modifier and water together to form a matrix, wherein the gelatin composition exhibits a bloom in the range of about 20 to about 250, wherein the plasticizer includes a polyol, and wherein the polymer modifier includes a carboxylic acid;
  - incubating the matrix;
  - cooling the matrix;
  - encapsulating the matrix in a sheath, wherein the sheath includes a plasticizer and a gelatin that exhibits a bloom in the range of about 80 to about 250.
67. The method of claim 66, wherein the temperature of the matrix is maintained in a range of about 40 to about 75 degrees Celsius during the incubating step.
68. The method of claim 66, wherein the incubating step is carried out over a time period of about 4 to about 72 hours.
69. The method of claim 66, wherein the matrix includes from about 0.1 to about 10 percent by weight carboxylic acid.
70. A chewable soft capsule comprising:
- a capsule matrix comprising
    - at least one gel-forming composition comprising a hydrophilic polymer, oligomer, polymer hydrolysate, or combinations thereof;
    - at least one plasticizer;
    - at least one polymer modifier; and,
    - water; and
  - a sheath comprising
    - at least one gel-forming composition comprising a hydrophilic polymer, oligomer, polymer hydrolysate, or combinations thereof;
    - at least one plasticizer;
    - at least one polymer modifier; and,

water from about 20% to about 50% prior to drying and from about 5% to about 20% after drying,  
wherein said capsule is prepared using rotary die machine.

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(71) Applicant (for all designated States except US): **BANNER PHARMACAPS, INC.** [US/US]; 4100 Mendenhall Oaks Parkway, Suite 301, High Point, NC 27265 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **HASSAN, EmadEldin, M.** [EG/US]; 4711 Champion Court, Greensboro, NC 27410 (US). **KINDT, Warren, W.** [US/US]; 3118 Sedgefield Gate Road, Greensboro, NC 27407-6103 (US). **GORDON, Roger, E.** [US/US]; 5803 Wildrose Drive, Greensboro, NC 27410 (US).

(74) Agents: **HICKS, Jack, B. et al.**; 300 North Greene Street, Suite 1900, Greensboro, NC 27401 (US).

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**Declarations under Rule 4.17:**

- as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii)) for the following designations AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NI, NO, NZ, OM, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VC, VN, YU, ZA, ZM, ZW, ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)
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(54) Title: CHEWABLE SOFT CAPSULE

(57) Abstract: A matrix formulation for a soft chewable capsule is provided which includes a gel-forming composition, a plasticizer, a polymer modifier and water. The polymer modifier may be a carboxylic acid or other organic compound that alters the physical and/or chemical properties of the capsule formulation. A chewable soft capsule is also provided, having enhanced organo-leptic and processing properties. An active material may be delivered to a user using this dosage form. A method of forming the chewable soft capsule is also provided.

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## B. FIELDS SEARCHED

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Electronic data base consulted during the International search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ, BIOSIS, EMBASE

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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X	EP 0 243 930 A (PHARMACAPS INC) 4 November 1987 (1987-11-04)  column 8, line 1 - line 46 column 9, line 15 - line 55 ---  -/--	1-3,8, 10-14, 25-30, 33-37, 42-44, 52, 56-58, 61-65,70

☒ Further documents are listed in the continuation of box C.

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European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3016

Authorized officer

VON EGGELKRAUT, S

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## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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